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<p>(54) Title: PREFORM AND BOTTLE USING PET/PEN BLENDS AND COPOLYMERS</p>		
<p>(57) Abstract</p>		
<p>The present invention relates to an injection molded preform (910) comprising an open ended mouth forming portion (912), an intermediate body forming portion, and a closed base forming portion (922) wherein said preform comprises (1) a blend of (i) PEN copolymer and (ii) PET homopolymer or PET copolymer, such that when said PET and PEN components are physically mixed into a blend, said blend has about 5-70 wt.% PEN copolymer and 30 to 95 wt.% PET homopolymer or copolymer therein, (2) a PEN copolymer, or (3) PEN homopolymer, and said preform having a stretch ratio in the range of 18:1 to 25:1 in order to form a bottle having a volume in the range of 250 ml to 850 ml, wherein the stretch index is below 130 cm. Alternatively, said preform has a stretch ratio in the range of 18:1 to 20:1 in order to form a bottle having a volume in the range of 250 ml to 1000 ml. The invention further relates to an injection mold defining a cavity corresponding to an injection molded preform of the invention. In addition, the invention relates to a blow-molded container (52) produced from the injection molded plastic preform described above.</p>		

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PREFORM AND BOTTLE USING PET/PEN BLENDS AND COPOLYMERS

Cross-Reference to Related Applications

This is a continuation-in-part application of U.S. serial No. 08/423,935 filed on April 18, 1995, which is
5 herein incorporated by reference in its entirety.

BACKGROUND OF THE INVENTION

This invention relates to new and useful improvements in manufacturing preforms for containers, such as plastic bottles, and to preforms and containers
10 per se. More particularly, the invention relates to a preform used to produce a plastic bottle which is recyclable, but preferably non-refillable.

A conventional PET (polyethylene terephthalate) preform (e.g. 12 ounces) is injection molded from PET
15 homopolymer or PET copolymer such that the resulting preform has a center sidewall thickness in the range of 3 to 4mm and a thickness in the base forming portion in the range of 3 to 4mm. The length of such a conventional PET preform for a 12 ounce bottle is in the
20 range of 90 to 95mm, and the injection molded preform has a stretch ratio in the range of at least 9:1, and preferably 9:1 to 12:1.

Conventional containers made of PET resins are often deficient in that such materials may have both
25 insufficient barrier properties and insufficient thermal stability. Reduced barrier properties of a container may adversely affect shelf life of a product provided within the container. In order to improve the barrier properties of a container, multilayer coatings are often

provided within the container.

Accordingly, there is a need in the art for containers having improved barrier properties in order to provide for longer shelf life of the product within the container.

U.S. Patent 5,102,705 to Yammoto et al. discloses a bottle made of polyethylene naphthalate resin and formed by stretching a preform so that the stretch index defined as follows is 130 cm or more:

$$\text{Stretch index} = \frac{\text{Internal volume of stretched bottle (excluding neck portion)}}{\text{Internal volume of preform before stretching (excluding neck portion)}} \times \frac{1}{f}$$

$$f = \frac{\text{Internal surface area of stretched bottle (excluding neck portion)} \text{ (cm}^2\text{)}}{\text{Internal volume of stretched bottle (excluding neck portion)}}$$

In contrast to the express teachings of the Yammoto et al. patent, the present invention operates only in the region corresponding to a stretch index of below 130cm. Thus, the present invention does not have a stretch index of 130cm or above.

SUMMARY OF THE INVENTION

Therefore, a primary object of the present invention is to obtain an injection molded preform capable of providing a blow-molded, non-refillable, recyclable container having improved barrier properties and without the need for additional protective layers in the container. However, the invention is not limited to non-refillable containers.

Another object of the invention is to provide a preform which does not require retooling of the container manufacturing process, except for the preform mold design *per se*. Thus, the preform of the invention and the resulting container are basically obtained from existing processing equipment.

The objects of the invention are fulfilled by the first embodiment of the invention which provides an injection molded preform comprising an open ended mouth forming portion, an intermediate body forming portion, and a closed base forming portion, wherein the preform is comprised of a blend of (i) about 5 to 99.9wt% (preferably about 5 to 70wt%) PEN copolymer, (i.e. containing 90-95 mol% NDC and 5-10 mol% terephthalate or other diacid), and (ii) 0.1 to 95wt% (preferably 30 to 95wt%) PET homopolymer or PET copolymer, based on the total weight of the preform, such that when said PET and PEN components are physically mixed into a blend, said blend has about 5-99.9wt% PEN copolymer therein and 0.1 to 95wt% PET homopolymer or copolymer therein, and the preform has a stretch ratio in the range of 18:1 to 25:1 in order to form a bottle having a volume in the range of 250 ml to 850 ml, wherein the stretch index is below 130cm, preferably below 125cm, more preferably below 100. Moreover, the injection molded preform preferably has a maximum wall thickness of about 8mm and a minimum wall thickness of about 2mm. The average wall thickness of the resulting bottle may be in the range of 0.25 to 0.65 mm.

A second embodiment of the invention is identical to the above-mentioned first embodiment, except said preform has a stretch ratio in the range of 18:1 to 20:1 in order to form a bottle having a volume in the range of 250 ml to 1000 ml, wherein the stretch index is below 130cm.

The objects of the invention are also fulfilled by providing an injection molded preform comprising an open ended mouth forming portion, an intermediate body forming portion, and a closed base forming portion, wherein said preform is comprised of a PEN copolymer or 100wt% PEN homopolymer based on the total weight of the preform, and said preform has a stretch ratio of 18:1 to 25:1 in order form a bottle having a volume in the range

of 250 ml to 850 ml, wherein the stretch index is below 130cm. In order to form a bottle having a volume in the range of 250 ml to 1000 ml, said preform has a stretch ratio of 18:1 to 20:1, wherein the stretch index is
5 below 130cm.

Accordingly, the composition of the preform may be any one of (i) a physical blend of suitable resins having about 5-99.9wt% (preferably 5-70wt%) PEN copolymer therein and having improved barrier properties
10 over existing PET formulations (i.e. no need for multilayers), (ii) 100wt% PEN homopolymer, or (iii) a PEN copolymer, and which provides a stretch ratio of 18:1 to 25:1 (or 18:1 to 20:1 depending on the desired volume of the bottle), wherein the stretch index is
15 below 130cm.

The injection molded preform of the invention ranges in size from (i) a first preform having a thickness in the range of about 3mm at the center side wall forming portion, a thickness of about 3mm in the
20 base forming portion, and a length of about 40mm, to (ii) a second preform having a thickness in the range of about 8.0mm (preferably 6mm) at the center side wall forming portion, a thickness of about 8.0mm in the base forming portion, and a length of about 100mm. This
25 brackets containers approximately in the range of 250ml to 850ml. To bracket an upper limit of 250ml to 1000ml would be the same, except that the length of the second preform would be about 110mm. Larger or smaller preforms may fall within the scope of the invention so long as
30 the preform retains a stretch ratio of 18:1 to 25:1 (i.e. for containers from 250ml to 850ml), or alternatively 18:1 to 20:1 (i.e. for containers from 250ml to 1000ml).

Accordingly, the injection molded preform of the
35 invention has a stretch ratio in the range of about 18:1 to about 25:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 850 ml. In order to

obtain containers (i.e. bottles) in the range of 250 ml to 1000 ml, the stretch ratio is in the range of 18:1 to 20:1.

In addition, because the preform of the invention comprises (1) a blend of (i) about 5 to 99.9wt% PEN copolymer and (ii) 0.1 to 95wt% PET homopolymer or PET copolymer, based on the total weight of the preform, such that when said PET and PEN components are physically mixed into a blend, said blend has about 5-99.9wt% PEN copolymer therein and 0.1 to 95wt% PET homopolymer or copolymer therein, (2) a 0.5 to 99.9 mol%, preferably 0.5 to 30 mol% or 80 to 99.9 mol% NDC containing PEN copolymer, for example, containing 0.5 to 50 mol% NDC and 50 to 99.5 mol% of a diacid (i.e. terephthalic acid), or is comprised of (3) 100wt% PEN homopolymer, based on the total weight of the preform, there is no need for the use of multilayer coatings to provide the improved barrier properties. Thus, the injection molded preform of the invention is preferably not of a laminated construction.

The invention is further directed to a container produced from any of the preforms of the invention. The container, for the most part, is highly biaxially oriented, but has a non-oriented neck finish for receiving a closure. Such a container is capable of receiving a hot fill product with a minimum of shrinkage and distortion.

Finally, the invention is directed to a mold for forming the preform of the invention as well as to a method for producing the containers from the preform of the invention.

Further scope of applicability of the present invention will become apparent from the detailed description given hereinafter. However, it should be understood that the detailed description and specific examples, while indicating preferred embodiments of the invention, are given by way of illustration only, since

various changes and modifications within the spirit and scope of the invention will become apparent to those skilled in the art from this detailed description.

BRIEF DESCRIPTION OF THE DRAWINGS

5 The objects of the present invention and the advantages thereof will become more readily apparent by reference to the following drawings.

FIGS. 1 and 2 are injection mold preforms of the invention.

10 FIGS. 3 and 10 show blow molded containers from an injection molded preform of the invention.

FIG. 4 shows a side view of the preform of the invention.

15 FIG. 5 shows the upper part of the preform shown in Fig. 4.

FIG. 6 shows the lower part of the preform shown in Fig. 4.

FIGS. 7 and 9 show generic preforms of the invention.

20 FIG. 8 shows blow-molding of the preform of FIG. 7.

FIG. 11 is a composite schematic vertical sectional view taken through a preform of the invention and shows how the preform is stretch blow molded to match the configuration of an existing mold cavity to form a
25 container of the invention.

FIG. 12 shows a preform of the prior art.

FIG. 13 shows a generic preform of the invention.

FIG. 14 shows a container of the invention. All values are in millimeters.

30 DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

The phrase "stretch ratio" as used herein refers to nomenclature that is customary and known in the art, as modified below. That is, the inventors intend that the conventionally known term "stretch ratio" is more
35 specifically defined as follows:

$$\text{Stretch Ratio} = \frac{\text{Maximum Bottle Diameter}}{\text{Internal Preform Diameter}} \times \frac{\text{Height of Bottle (without finish)}}{\text{Height of Preform (without finish)}}$$

5 Therefore, whenever the inventors refer to the term "stretch ratio" in the present application, they are more specifically referring to the "stretch ratio" as defined above.

10 The present invention relates to the manufacture of preforms for containers, such as bottles, and to the preforms and containers *per se*. The injection molded preform comprises an open ended mouth forming portion, an intermediate body forming portion, and a closed base forming portion. The preform comprises a blend of (i)
 15 about 5 to 99.9wt% (preferably about 5 to 70wt%) PEN copolymer, (i.e. containing 90-95 mol% NDC and 5-10 mol% terephthalate or other diacid), and (ii) 0.1 to 95wt% PET homopolymer or PET copolymer, based on the total weight of the preform, such that when said PET and PEN
 20 components are physically mixed into a blend, said blend has about 5 to 99wt% (preferably 5 to 70wt%) PEN copolymer therein, and 0.13 to 95wt% (preferably 30 to 95wt%) PET homopolymer or copolymer therein. The preform has a stretch ratio in the range of about 18:1
 25 to about 25:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 850 ml. In order to obtain containers (i.e. bottles) in the range of 250 ml to 1000 ml, the stretch ratio is in the range of 18:1 to 20:1. The injection molded preform of the invention may
 30 also be comprised of a 0.5 to 99 mol%, preferably 0.5 to 30 mol% or 80 to 99.9 mol% NDC containing PEN copolymer, for example, containing 0.5 to 50 mol% NDC and 50 to 99.5 mol% of a diacid (i.e. terephthalic acid), or 100wt% PEN homopolymer based on the total weight of the
 35 preform, so long as the preform has a stretch ratio of 18:1 to 25:1 (preferably 23.6:1 for a 12 ounce bottle) for containers in the range of 250ml-850ml and 18:1 to 20:1 for containers in the range of 250ml and 1000ml.

In all embodiments of the present invention, the stretch index is below 130cm, preferably below 125cm, and more preferably below 100cm.

5 The invention is based upon a preform mold design which maintains the stretch ratio at least about 18:1 (FIGS 1-2). The invention incorporates designs ranging from 14 to 23% shorter in length than conventional preform designs with a sidewall thickness 39 to 52 % greater than conventional designs, with 39 to 58%
10 greater thickness in the base forming region than conventional designs.

Generally speaking, the preform ranges in size from (i) a first preform (i.e. 250 ml) having a thickness in the range of about 3mm at the center side wall forming
15 portion, a thickness of about 3mm in the base forming portion, and a length of about 40mm, to (ii) a second preform (i.e. 850 ml) having a thickness in the range of about 8.0mm, preferably 6mm, at the center side wall forming portion, a thickness of about 8.0mm, preferably
20 6mm, in the base forming portion, and a length of about 100mm. Larger or smaller preforms may fall within the scope of the invention so long as the preform retains a stretch ratio of about 18:1 to about 25:1 and the stretch index is below 130cm. A preform for forming a
25 container of up to 1000ml may used, but such preform would have a stretch ratio of about 18:1 to about 20:1, a stretch index below 130cm and it would have a thickness in the range of about 8.0mm, preferably 6mm, at the center side wall forming portion, a thickness of
30 about 8.0mm, preferably 6mm, in the base forming portion, and a length of about 110mm. The preform of the invention is preferably not of a laminated construction.

The preforms and containers are produced from
35 physical PET/PEN resin blends, PEN copolymers, or PEN homopolymers, as discussed below.

Methods for making the PET homopolymers, PET

copolymers as well as the PEN homopolymers and PET copolymers *per se* are known in the art.

Physical Blends

Physical mixtures contain (i) a PET homopolymer or
5 PET copolymer and (ii) a PEN copolymer. The PEN
copolymer of the blend is at least 0.5 mol% to 99.9 mol%
2,6-naphthalene-dicarboxylate, (NDC, Amoco Chemical
Company), and 0.1 to 99.5 mol% of another diacid
10 component (i.e. terephthalic acid), most preferably 92
to 99.9 mol% 2,6-naphthalene-dicarboxylate and .1-8 mol%
of another diacid component (i.e. terephthalic acid),
such that when said PET and PEN components are
physically mixed into a blend, said blend has about 5 to
99.9wt% (preferably 5-70wt%) PEN copolymer therein and
15 0.1 to 95wt% (preferably 30 to 95wt%) PET homopolymer or
copolymer therein.

In one embodiment of the invention, the injection
molded preform is injection molded from a physical
mixture of (i) a first component of a PEN copolymer, and
20 (ii) a second component of PET homopolymer or PET
copolymer, such that when said first and second
components are physically mixed into a blend, said blend
contains about 5wt% to 50wt% PEN copolymer and 50 to
95wt% PET homopolymer or PET copolymer based on the
25 total weight of the preform.

In order to obtain the PEN copolymer, the pellet
size of the PET copolymer or homopolymer (i.e. 0.8 to
0.84 intrinsic viscosity) is matched with the pellet
size of the PEN homopolymer so that the pellets of each
30 component are of similar size. This matching of pellet
sizes avoids an undesirable sifting effect (i.e.
physical separation of PEN and PET pellets). However,
the size of the matched pellets *per se* is not important
to the operation of the invention. Thus, a blend is a
35 physical mixture of the PET and PEN components, which
are mixed in any arbitrary ratio so long as the final
blend is 5 to 99.9wt%, preferably 5 to 70wt% PEN

copolymer, more preferably 5 to 50wt% PEN copolymer, and even more preferably 15 to 35wt% PEN copolymer.

In the injection molded preform according of the invention, said preform is injection molded from a physical mixture of (i) 5 to 76wt%, preferably 5 to 54wt%, more preferably 16 to 38wt% of a first component of a PEN copolymer based on the total weight of the preform, and (ii) 24 to 95wt%, preferably 46 to 95wt%, more preferably 62 to 84wt% of a second component of PET homopolymer or PET copolymer based on the total weight of the preform, such that when said first and second components are physically mixed into a blend, said blend contains about 5wt% to 50wt% PEN copolymer and 50 to 95wt% PET homopolymer or PET copolymer based on the total weight of the preform.

In the injection molded preform of the invention, examples of a PEN copolymer, homopolymer and/or terpolymer include Hoechst Celanese T94, Teijin TN8756T, Teijin TC4 homopolymer, Teijin TC6, and examples of a PET copolymer include Shell 8006, 8406 Eastman 9921, Hoechst, T-80, and ICI 5827.

The first component of the blend may include up to 76wt% PEN copolymer based on the total weight of the preform.

The second component of the blend may include up to 95wt% PET homopolymer or PET copolymer based on the total weight of the preform.

In another embodiment of the invention, the preform is injection molded from a physical mixture of (i) 5 to 76wt%, preferably 5 to 54wt%, more preferably 16 to 38wt%, of a first component of a PEN copolymer based on the weight of the preform, said PEN copolymer comprising about 5 to 8 mol% PET, and 92 to 95 mol% PEN, and (ii) 24 to 95wt% , preferably 46 to 95wt%, more preferably 62 to 84wt% of a second component of PET homopolymer or PET copolymer, such that when said first and second components are physically mixed into a blend, said blend

has about 5 to 50wt% PEN copolymer and 50 to 95wt% PET homopolymer or copolymer based on the weight of the preform, said blend being injection molded such that the preform has a thickness in the range of 3 to 8mm at the center side wall forming portion and a thickness in the range of 3 to 8mm in the base forming portion, the length of the preform being in the range of 73 to 110mm.

PEN HOMOPOLYMER

The injection molded preform of the invention may also be comprised of 100wt% PEN homopolymer based on the total weight of the preform, so long as the preform maintains a stretch ratio in the range of about 18:1 to about 25:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 850 ml, or in the range of 18:1 to 20:1 in order to obtain containers in the range of 250 ml to 1000 ml. A PEN homopolymer of the invention is not a blend of PEN homopolymer and PET.

PEN COPOLYMER

A PEN copolymer of the invention is distinguished from a physical blend referred to above. A PEN copolymer is basically formed from a reaction of NDC (Amoco Chemical Company) with another diacid component and ethylene glycol or other dihydroxy compounds to form a resin (e.g. U.S. Patent 5,039,780). For instance, 5 to 99.9 mol% NDC is reacted with a total of 0.1 to 99.5 mol% of terephthalic acid and/or other diacids and a total equimolar amount of ethylene glycol and/or other dihydroxy compounds to form a PEN copolymer. An example of a PEN copolymer contains 92 mol% NDC and 8 mol% terephthalic acid polymerized with ethylene glycol.

In one embodiment of the invention, the injection molded preform comprises 0.5 to 99.9 mol% NDC, more preferably 0.5 to 50 mol% NDC containing PEN copolymer.

The acid component of the PEN copolymer may contain one or more of the following including terephthalic acid, isophthalic acid (IPA), diphenylether 4,4'-dicarboxylic acid, naphthalene-1,4-dicarboxylic acid,

adipic acid, sebacic acid, decane 1,10-dicarboxylic acid, and hexahydroterephthalic acid. Examples of the residual glycol component are propylene glycol, 1,4-butane diol, neopentyl glycol, diethylene glycol, 2,2-bis(4-hydroxyphenyl)-propane, 2,2-bis(4-hydroxyethoxyphenyl) propane, and cyclohexane dimethanol (CHDM).

A PEN copolymer when injection molded in accordance with the preform dimensions of the invention is within the scope of the invention if the injection molded preform of the invention has a stretch ratio in the range of about 18:1 to about 25:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 850 ml, or a stretch ratio is in the range of 18:1 to 20:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 1000 ml. Examples of a PEN copolymer are Hoechst T91, Shell VFR 40019, and Teijin TC6.

In one embodiment of the invention, the preform is comprised of a PEN copolymer containing about 5 to 50 mol% NDC and about 50 to 95 mol% of terephthalic acid and/or other diacids.

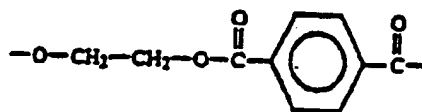
In another embodiment of the invention, the preform is comprised of a PEN copolymer containing about 15 mol% to 35 mol% NDC and about 65 to 85 mol% terephthalic acid and/or other diacids.

In another embodiment of the invention, the preform is comprised of a PEN copolymer containing about 5 mol% to 20 mol% NDC and about 80 to 95 mol% terephthalic acid and/or other diacids.

In a preferred embodiment of the invention, the preform is comprised of a PEN copolymer containing about 15 mol% to 25 mol% NDC and about 75 to 85 mol% terephthalic acid and/or other diacids.

PET polymers are generally prepared from terephthalic acid or its ester forming derivatives and ethylene glycol or its ester forming derivatives. In general, at least about 97% by weight of the polymer can

comprise repeating ethylene terephthalate groups of the formula:



The remainder of the polymer can comprise various ester forming compounds.

- 5 The present invention contemplates the use of copolymers of the polyethylene terephthalate in which a minor proportion, for example, up to about 25% by weight, of the ethylene terephthalate units are replaced by compatible monomer units in which the dicarboxylic
- 10 acid moiety of the monomer is replaced by 2,6-naphthalenedicarboxylate, aromatic dicarboxylic acids such as isophthalic acid, phthalic acid, naphthalenedicarboxylic acid, diphenyldicarboxylic acid, diphenoxyethanedicarboxylic acids, bibenzoic acid, and
- 15 aliphatic or alicyclic dicarboxylic acids such as adipic acid, sebacic acid, azelaic acid, decanedicarboxylic acid and cyclohexanedicarboxylic acid. The glycol moiety of the monomer may be replaced by aliphatic or alicyclic glycols such as cyclohexanedimethanol, trimethylene glycol, polytetramethylene glycol, hexamethylene glycol, dodecamethylene glycol, diethylene glycol, polyethylene glycol, polypropylene glycol, propane-1,3-diol, butane-1,4-diol, and neopentyl glycol, bisphenols and other aromatic diols such as hydroquinone
- 20 and 2,2-bis(4'-B-hydroxethoxyphenyl)propane. In addition, various multifunctional compounds such as trimethylolpropane, pentaerythritol, trimellitic acid and trimesic acid can be copolymerized with the polyethylene terephthalate polymer in amounts of up to
- 25 about 2 percent by weight.
- 30

The polyethylene terephthalate polymers useful in the present invention can also contain other compatible additives and ingredients which do not adversely affect performance characteristics of the container such as adversely affecting the taste or other properties of products packaged therein. Examples of such ingredients include thermal stabilizers, light stabilizers, dyes, pigments, plasticizers, fillers, antioxidants, lubricants, extrusion aids, residual monomer scavengers and the like.

The plastic resins useful for making the container of this invention include homopolymers of PEN and PET, and copolymers of PEN and PET. The intrinsic viscosity of PEN is about 0.6 I.V. to about 0.9 I.V., preferably about 0.7 IV. PET having an intrinsic viscosity of from about 0.55 to about 1.04 and preferably from about 0.55 to 0.9 can be employed as the starting material used in producing the preforms of the invention. When the intrinsic viscosity is less than 0.6 I.V., the mechanical strength of the resulting container is not sufficient.

PEN and PET homopolymer resins and PEN and PET copolymer resins useful in this invention are commercially available from Teijin in Japan, Eastman Chemicals in Tennessee, Shell in Akron Ohio, ICI, and Hoechst Celanese.

The invention preferably relates to preforms for making containers for packaging applications in the carbonated and non-carbonated soft drink industry. The manufacturing method to form these preforms includes injection molding, and for the containers includes, but is not limited to single stage, two stage, and double blow molding manufacturing systems. The invention results in a lighter weight bottle as compared to existing PET bottles, having a highly oriented base.

Methods for forming containers of the invention include injection-blow molding. In injection-blow

molding the preform is formed from an injection molded blowable geometric form. The preform or blowable form is then contained within a mold cavity having the volumetric configuration of the desired container and the preform is expanded by blowing it with compressed air within the confines of the mold cavity.

Commercially available equipment, as is used in the manufacture of thin walled single use PET beverage containers, may be used to make the containers of the present invention. In addition, commercial equipment like that used in manufacturing conventional thick wall refillable PET containers may also be used.

The container of the invention is rigid and resilient, rather than squeezable. That is, squeezability is undesirable since the inventive container is for pourable applications. Thus, the container formed from the preform of the invention has an average wall thickness of at least 0.25mm, and more preferably an average wall thickness in the range of 0.25 to 0.8mm (preferably 0.35mm).

A preferred preform, which is then blow molded into a biaxially-oriented container, with an overall stretch ratio from 18:1 to 25:1 for containers in the range of 250ml to 850ml (or a stretch ratio of 18:1 to 20:1 for containers in the range of 250ml to 1000ml) comprises a first component which is a PEN copolymer, and a second component which is commercially available PET homopolymer or copolymer, such as Shell Polyester 8006 and 8406. These components are physically mixed into a blend which has about 5wt% to 70wt% PEN therein, preferably 5 to 35wt% PEN therein. The blend is injection molded such that the preform has a thickness in the range of 3 to 8.0mm (with a preferred upper limit of 6mm) at the center side wall forming portion and a thickness in the range of 3 to 8.0mm (with a preferred upper limit of 6mm) in the base forming portion, the length of the preform being in the range of 40 to 110mm.

The injection molded preform, when blow-molded, has a stretch ratio in the range of about 18:1 to about 25:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 850 ml, or a stretch ratio is in the range of 18:1 to 20:1 in order to obtain containers (i.e. bottles) in the range of 250 ml to 1000 ml.

A typical container of the invention is 850 liters, substantially cylindrical in shape, about 220mm in height without the cap and about 77mm in outer diameter. The sides of the container are biaxially oriented and radially expanded in a blow mold, and has a side-wall thickness of about 0.25 to 0.65mm.

FIG. 13 represents a typical preform of the invention. The length of the preform along 1-1 is in the range of 40 to 100mm. The center side wall thickness along 2-2 is in the range of 3mm to 8.0mm. The base forming region thickness also along 1-1 is in the range of 3 to 8.0mm. The length, center side wall and base thickness may vary so long as the stretch ratio is as defined above. The wall thickness along 3-3 is in the range of 3-8.0mm. The wall thickness along 4-4 is in the range of 3-8.0mm. The wall thickness along 5-5 is in the range of 1.7-6.5mm, preferably 1.7-3.5mm.

The container of the invention may be blow-molded from a cylindrical injection-molded preform having an open top end and neck finish (See Figs. 1 and 2). The preform may have a tapered shoulder-forming portion, substantially uniform thickness along the sides of the cylinder, and a base-forming portion preferably in a champagne design, but including a hemispherical base with a base cup or a footed design such as a petaloid design. The preform is amorphous and substantially transparent and is injection molded from a physical mixture of said first and second components, PEN copolymers, or may comprise 100% NDC (PEN homopolymer) as the acid component. However, other materials and preform shapes having the necessary plastic composition

and preform dimensional requirements can be used, including preforms with thickened base forming portions to provide a thicker container base having improved creep resistance, or preforms with variable wall thickness portions in the side wall if desired.

The preform is subsequently placed in a blow molding apparatus having an upper mold section which engages the neck finish, a middle mold section having an interior cavity forming the shape of the container side wall, and a lower mold section having an upper surface forming the outwardly concave dome portion of the container base. In accordance with a standard reheat stretch blow mold process, the injection-molded preform is first reheated to a temperature suitable for stretching and orientation, placed in the blow mold, and an axial stretch rod is then inserted into the open upper end and moved downwardly to axially stretch the preform. Subsequently or simultaneously an expansion gas is introduced into the interior of the preform to radially expand the shoulder, sidewall and base forming portions outwardly into contact with the interior surfaces of mold sections.

The blown container (Fig. 3) has the same neck finish with outer threads and lowermost neck flange as the preform. The remainder of the bottle has undergone expansion, although to varying degrees. An upper tapered shoulder portion may gradually increase in diameter and orientation while moving downwardly along the bottle. Below the shoulder section may be a radially outwardly projecting upper bumper portion. Below the ornamental panel section where the label may be placed may be a radially outwardly projecting lower bumper, and then a champagne-style base. The base may include an outer base wall gradually reducing in diameter moving downwardly from the upper bumper to a lowermost contact radius on which the bottle rests. Radially inwardly of the contact radius may be a

recessed inner base wall or dome having a central gate region. The inner base wall or dome may include a number of symmetrical recessed petaloid portions for increasing the thermal resistance of the base, as is known in the art. In general, the relatively low oriented base has a greater thickness for strength, while the side wall section has a relatively high orientation for strength.

A removable cap is attached to the open upper end of the container. The cap includes a base portion having internal threads which engage the outer threads on the neck finish.

In the container of the invention, there is no need for vacuum panels to be disposed about the vertical centerline of the container. Further, there is no need for post walls in the container of the invention. Moreover, there is no requirement for additional vertically-elongated reinforcing ribs to further stiffen the walls.

The container of the invention may be used for any cosmetic, food, beverage, etc., product which requires a pourable rather than a squeezable container. The product may be pressurized, e.g. carbonated soft drink, or nonpressurized, e.g. juice. In the case of a hot fill product, for instance, juice, vacuum panels could be used. Alternatively, a drop of liquid nitrogen would serve to counter-pressure the container and vacuum panels would not be needed. The container may be used with either hot-fill or cold-fill products wherein the construction provides pourability. For instance, the container formed from the preform of the invention should be able to withstand hot-fill temperatures in the range of 83 - 85°C and higher, without deformation.

The container may be made in a variety of sizes (volume) and shapes (height and diameter). For example, a twelve ounce pourable (i.e. rather than squeezable), container may have a 58.42mm major diameter and an

average wall thickness of at least about 0.635mm.

In making the preferred container from an amorphous preform according to the reheat stretch blow process, a suitable stretching temperature range is about 70° - 130°C. In a preferred embodiment of the invention, the combined axial and circumferential extension is at least 18:1, with an upper limit of 20:1 or 25:1, depending on the desired size of the container.

If desired, a multi-layer preform may be used. However, in the present invention, it should be unnecessary to provide a barrier layer, since the PEN component is present in an amount to provide sufficient barrier properties.

Containers of the invention may contain ornamental panels, but these panels are primarily for design, ornamental use only.

A preform of the invention is further illustrated in FIGS. 4, 5 and 6. The preform 410 is injection molded from a plastic comprising a physical mixture of (i) a PEN copolymer and (ii) a second component of PET homopolymer or PET copolymer, such that when said first and second components are physically mixed into a blend, said blend has about 5% to 99.9wt% PEN therein. Alternatively, the preform is injection molded from a PEN copolymer having about 1 to 25 mol% NDC, or from PEN homopolymer. The preform has a thickness in the range of 3 to 8.0mm at the center side wall forming portion and a thickness in the range of 3 to 8.0mm in the base forming portion, the length of the preform being in the range of 40 to 100mm, said injection molded preform preferably having a stretch ratio in the range of about 18:1 to about 25:1. Generally speaking, the various portions of the preform 410 may be identified as including a base portion 412, a body portion 414, a neck finish portion 416 and a neck to body transition 418.

Referring to FIG. 5, it will be seen that the upper part of the preform 510 is illustrated in detail. First

of all, the illustrated neck finish portion 516 is in the form of a conventional neck finish which may include external threads 520 for receiving a closure, a locking bead 522 for engagement by a closure tamper indicating ring or band, and a lower flange 524.

Immediately below the flange 524 is the neck to body transition 518. It starts with an internal thickening to define a seat 526 for receiving, for example, a blow nozzle in seated engagement. Immediately below the seat, the transition may include a cylindrical part 528. Below the cylindrical part 528, the transition 518 downwardly tapers in thickness externally as at 530 terminating in a further cylindrical part 532 of minimal cross section. Below the cylindrical part 532, the transition 518 flares both internally and externally as at 534 to join the greater thickness body portion 514.

Referring now to FIG. 6, it will be seen that the base portion 612 begins at the lower end of the body 614 with a radius part 636 which joins a frustoconical part 638 to the body portion 614. The frustoconical part, in turn, carries a part spherical bottom 640 which tapers in thickness from the frustoconical part 638.

It is to be understood that the preform 610 is formed by injection molding and when presented to blow molding apparatus (not shown) is at room temperature. A preform, in a normal blow molding operation, is heated by a series of quartz heaters which results in the heating of the outer surface of the preform to a higher temperature than the inner surface. On the other hand, radio frequency heating has been utilized with the result that the inner surface of the preform is heated to a higher temperature. Hybrid heating utilizing a combination of quartz heaters and radio frequency heaters has been utilized in the past to obtain a uniform temperature throughout the wall of the preform. Such a heating process is disclosed in U.S. Pat. Nos.

4,863,046 and 4,407,651.

As illustrated in FIGS. 7 and 8, a container of the invention 810 is blow molded from a cylindrical injection molded preform 72 having an open top end 711 and neck finish 712. This preform has a tapered shoulder-forming portion 75, substantially uniform thickness panel forming portion 73, and a base forming portion 74 including a substantially hemispherical bottom end. The preform 72 is amorphous and substantially transparent and may be made of (a) a mixture of PEN copolymer and PET homopolymer or PET copolymer to form a blend in the range of 5-99.9wt% PEN copolymer, preferably 5-70wt% PEN copolymer, more preferably 15-35wt% PEN copolymer, (b) a PEN copolymer containing 5 to 20 mol% NDC and the remainder another diacid (i.e. terephthalic acid), or (c) PEN homopolymer.

As shown in FIG. 8, the preform 82 is placed in a blow molding apparatus 896 having an upper mold section 896A which engages the neck finish 812, a middle mold section 896B having an interior cavity forming the shape of the container side wall, and a lower mold section 896 having an upper surface forming the outwardly concave dome portion of the container base. In accordance with a standard reheat stretch blow mold process, the injection-molded preform 82 is first reheated to a temperature suitable for stretching and orientation, placed in the blow mold, and an axial stretch rod 97 is then inserted into the open upper end 811 and moved downwardly to axially stretch the preform. Subsequently or simultaneously an expansion gas 890 is introduced into the interior of the preform to radially expand the shoulder, sidewall and base forming portions outwardly into contact with the interior surfaces of mold sections 896B and 896C.

The blown container (not shown) obtained from Fig. 8 has the same neck finish with outer threads and lower most neck flange as the preform. The remainder of the

bottle has undergone expansion, although to varying degrees.

The present invention has applications beyond the above illustrated preforms and beverage container. More generally, the container may be used for any cosmetic, food, beverage, etc, product. The product may be pressurized, e.g. beer, or nonpressurized, e.g. juice. The container may be used with cold-fill or hot-fill products.

10 The container may be made in a variety of sizes (volume) and shapes (height and diameter). For example, the blow-molded container produced from the injection molded plastic preform of the present invention may be a container (i.e. bottle) having a volume of about 250
15 ml, 300 ml, 333 ml, 355ml, 472 ml, 500 ml, 590ml, 750ml, 850 ml or 1000 ml, as well as the corresponding English unit equivalents, and a container (i.e. bottle) having a volume of about 12 ounces, 16 ounces, 20 ounces or 24 ounces. In calculating a stretch ratio of the present
20 invention, the preform internal height and internal diameter is necessary for the calculation. In this regard, the ratio of the preform height (as measured below the finish) to the internal preform diameter is preferably at least 5:1.

25 In making a container from an amorphous preform according to the reheat stretch blow process, a suitable stretching temperature range is about 70°-170° C. It is advisable to stretch the preform to about 18 to 25 combined axial and circumferential stretch.

30 It is not necessary to provide a multi-layer preform, e.g. with one or more barrier layers, for a specific product which is degraded by oxygen, moisture, light, etc.

A preform may be reheated on a conventional stretch
35 blow molding machine equipped with a quartz IR reheat oven wherein the preform is heated to a temperature just prior to stretch blowing on the order of 225°F. to

245°F. The blow mold, however, is heated so that the blown container may be maintained at 175° to 325°F for three to five seconds.

This technology may be utilized in conjunction with
5 a preform configured to yield an initial wall thickness of 0.200 inch and a final bottle wall thickness of 0.025 inch with a total preform draw ratio of 25 to one. This preform may have a weight of 93 grams and a length below the neck finish of 6.250 inches
10 and a mid body diameter of 1.250 inches.

Further, the length of the tapered portion of the preform may be greatly increased which permits orientation of the shoulder area to within 0.1 inch of the finish area for a generic 850 ml bottle
15 configuration.

Drop impact failures in one piece champagne base configuration containers usually occur in the unoriented, amorphous area of the base due to the reduced strength of this area vs. the oriented
20 sidewalls. Crack failures usually initiate in the chime area (radius 32) at the point of impact and propagate through the unoriented wall thickness. To minimize impact failure, the preform may be modified so as to reduce the length of the flute thereby reducing the
25 unoriented wall thickness in the base chime area (radius 32).

In another embodiment, reference is made to FIG. 9 wherein there is illustrated the vertical cross section of a preform formed in accordance with this invention,
30 the preform being generally identified by the numeral 910. The upper part of the preform 910 includes a threaded neck finish 912 which terminates at its lower end in a capping flange 914. Below the capping flange 914, there is a generally cylindrical section 916 which
35 terminates in a section 918 of gradually increasing external diameter so as to provide for an increasing wall thickness. Below the section 918, there is an

elongated body section 920, the extreme lower part of which forms an upper part of a container base forming portion generally identified by the numeral 922.

5 The wall thickness of the various portions of the container 52 above the base construction 56 are clearly shown in FIG. 10. At this time it is pointed out that the container 52 is a 1.5 liter bottle and the preform 910 is configured to form the container 52.

10 In another embodiment of the invention as shown in FIG. 11, the preform 120 is stretch blow molded in a conventional mold 400 of a split construction utilizing a stretch rod 420. The mold 400 has a cavity 420 of a configuration for forming the container 100. The shoulder forming portion 200 is stretched both so as to
15 be axially elongated and of an increased diameter to form a tapered shoulder 440 on the container 100. Next, it will be seen that the preform body portion 220 has a thickness t_p and a length corresponding to an intended length of a container body 460. The specific wall
20 thickness and length ratio between the preform body portion 220 and the container body 460 is one wherein the container body 460 is provided with a stretch ratio (thickness reduction) on the order of 18:1 to 25:1. The
25 thus formed container body 460, being biaxially oriented, has a high resistance to internal pressurization of the container 100 while having very little resistance to radially inwardly collapse when there is a negative pressure or vacuum within the container 100.

30 Finally, the base forming portion 240 of the preform is stretched to form a base 480 of the container 100 which may include a plurality of legs which are circumferentially spaced and which project from a generally hemispherical portion having a recessed center
35 so that the container seats on feet defined by the legs.

By increasing the wall thickness of the base portion 240 of the preform 120, the base 480 is of a

greater thickness. Further, as the base portion 240 of the preform 120 is axially stretched, as well as being stretched in the hoop direction, the greater wall thickness gives a higher section modulus which lowers the applied stresses. The combination of thicker walls and increased orientation in the base 480 permits a higher initial internal pressurization of the container.

The invention is further directed to an injection mold defining a cavity corresponding to an injection molded preform of Figures 1, 2 or 13.

The invention is also directed to blow-molded containers produced from the injection molded plastic preform described hereinabove.

EXAMPLE

Sample 1 - (Control) PET resin

Step A: 21.5 grams of Shell 8006 resin obtained from Shell Polyester Akron, Ohio is injection molded in a mold to produce a preform as shown in Fig. 12. The preform contains PET copolymer with an IV of about .80. Injection molding conditions include a temperature range of 280-290°C with a cycle time of 35 seconds in a single cavity Arburg 320 Injection Press.

Step B: The resulting preform is blow molded with an LB01 blow molding machine to produce a bottle similar to Figure 14, resulting in an overall stretch ratio of 9:1. Blow molding conditions include preform reheat time of 60 seconds and a blow pressure of 38 bar. More specifically, a preform reheat time of 15 seconds is for 2 heating locations and 2 equilibration locations for a total reheating time of 60 seconds.

Sample 2 - Pre-blended Resin

Step A: 21.5 grams of Shell Polyester VFR40038 blend resin obtained from Shell Polyester, Akron, Ohio is

injection molded in a mold which produces a preform as shown in Figure 1. The preform contains 5-70% PEN, with an IV of about .73. The resin is injection molded using a single cavity Arburg 320 Injection Press at 290-295°C with a 40 second cycle time.

Step B: The resulting preform is blow molded with an LB01 blow molding machine to produce a bottle as in Figure 14 having an overall stretch ratio of 21:1 (e.g. 20.79:1). Blow molding preform reheat time is at 28 seconds with a blow pressure of 36 bar.

The dimensions and properties of the 12 ounce contour bottle shown in FIG. 14 and the preform shown in FIG. 1 are as follows:

	Bottle height (excluding finish)	177.2mm
15	Maximum bottle diameter	59.5mm
	Bottle surface area (excluding finish)	298.39cm ²
	Internal vol. of bottle (excluding finish)	372cc
	Internal vol. of preform (excluding finish)	6.2cc
	Height of preform (excluding finish)	58.369mm
20	Internal diameter of preform	8.69mm
	Stretch index	74.8cm
	Stretch ratio	21

The barrier properties of the bottles are measured as described in U.S. Patent 5,473,161, which is herein incorporated by reference in its entirety, to give the following results:

<u>CO₂ (% Loss/Week)</u>	
VFR40038	2.45
8006 (Control)	3.38

Sample 3 - Pre-blended Resin

Step A: 21.5 grams of Shell Polyester VFR40039 blend resin obtained from Shell Polyester, Akron, Ohio is injection molded in a mold which produces a preform as shown in Figure 1. The preform contains 5-70wt% PEN with and IV of about .73. The resin is injection molded using a single cavity Arburg 320 Injection Press at 280-285°C with a 40 second cycle time.

Step B: The resulting preform is blow molded with an LB01 blow molding machine to produce a bottle as in Figure 14, having an overall stretch ratio of 21:1. Blow molding preform reheat time is at 25 seconds with a blow pressure of 36 bar.

The barrier properties of the bottles measured as described in said copending application U.S. Serial No. 08/262,846 are as follows:

<u>CO₂ (% Loss/week)</u>	
VFR40039	2.40
8006	3.38

Sample 4 - PEN Copolymer

Step A: 21.5 grams of Shell Polyester VFR40019 copolymer resin obtained from Shell Polyester, Akron, Ohio, is injection molded in a mold which produces a preform as shown in Figure 1. The preform contains 1-25wt% PEN, with an IV of about .70. The resin is injection molded using a single cavity Arburg 320 Injection Press at 275-285°C with a 37 second cycle time.

Step B: The resulting preform is blow molded with an LB01 blow molding machine to produce a bottle of Figure 14, resulting in an overall stretch ratio of 21:1. Blow molding preform reheat time is at 22 seconds with a blow

pressure of 36 bar.

The barrier properties of the bottles, measured as described in copending application U.S. Serial No. 08/262,846 are as follows:

5		<u>CO₂ (% Loss/Week)</u>	
	VFR40019		2.66
	8006		3.38

All U.S. patents cited above are herein incorporated by reference in their entirety.

10 The invention being thus described, it will be obvious that the same may be varied in many ways. Such variations are not to be regarded as a departure from the spirit or scope of the invention, and all such modifications as would be obvious to one skilled in the art are intended to be included within the scope of the following claims.

15

What is claimed is:

1 1. An injection molded preform comprising an open
2 ended mouth forming portion, an intermediate body
3 forming portion, and a closed base forming portion,
4 wherein said preform comprises:

5 (1) a physical blend of (i) PEN copolymer and (ii)
6 PET homopolymer or PET copolymer, such that when said
7 PET and PEN components are physically mixed into a
8 blend, said blend contains about 5-99.9wt% PEN copolymer
9 and about 0.1 to 95wt% PET homopolymer or copolymer
10 therein,

11 (2) a 0.5 to 99.9 mol% NDC containing PEN
12 copolymer, or

13 (3) PEN homopolymer, and

14 said preform having a stretch ratio in the range of
15 18:1 to 25:1 in order to form a bottle having a volume
16 in the range of 250 ml to 850 ml, wherein the stretch
17 index is below 130cm.

1 2. The injection molded preform according to claim
2 1, wherein said preform has a maximum thickness of 8mm.

1 3. An injection molded preform comprising an open
2 ended mouth forming portion, an intermediate body
3 forming portion, and a closed base forming portion,
4 wherein said preform comprises:

5 (1) a physical blend of (i) PEN copolymer and (ii)

6 PET homopolymer or PET copolymer, such that when said
7 PET and PEN components are physically mixed into a
8 blend, said blend contains about 5-99.9wt% PEN copolymer
9 and about 0.1 to 95wt% PET homopolymer or copolymer
10 therein,

11 (2) a 0.5 to 99.9 mol% NDC containing PEN
12 copolymer, or

13 (3) PEN homopolymer, and

14 said preform having a stretch ratio in the range of
15 18:1 to 20:1 in order to form a bottle having a volume
16 in the range of 250 ml to 1000 ml, wherein the stretch
17 index is below 130 cm.

1 4. The injection molded preform according to claim
2 3, wherein said preform has a maximum thickness of 8mm.

1 5. The injection molded preform according to claim
2 1, comprising an open ended mouth forming portion, an
3 intermediate body forming portion, and a closed base
4 forming portion, wherein said preform comprises a blend
5 of (i) PEN copolymer and (ii) PET homopolymer or PET
6 copolymer, such that when said PET and PEN components
7 are physically mixed into a blend, said blend has about
8 5-99.9wt% PEN copolymer and about 0.1 to 95wt% PET
9 homopolymer or copolymer therein, said preform having a
10 stretch ratio in the range of 18:1 to 25:1 in order form
11 a bottle having a volume in the range of 250 ml to 850
12 ml, wherein the stretch index is below 130cm.

1 6. The injection molded preform according to claim
2 1, comprising an open ended mouth forming portion, an
3 intermediate body forming portion, and a closed base
4 forming portion, wherein said preform comprises a 0.5 to
5 50 mol% NDC containing PEN copolymer and said preform
6 having a stretch ratio in the range of 18:1 to 25:1 in
7 order form a bottle having a volume in the range of 250
8 ml to 850 ml, wherein the stretch index is below 130cm.

1 7. The injection molded preform according to claim
2 1 comprising an open ended mouth forming portion, an
3 intermediate body forming portion, and a closed base
4 forming portion, wherein said preform is comprised of
5 PEN homopolymer and said preform has a stretch ratio in
6 the range of 18:1 to 25:1 in order form a bottle having
7 a volume in the range of 250 ml to 850 ml, wherein the
8 stretch index is below 130cm.

1 8. The injection molded preform according to claim
2 1, wherein said preform ranges in size from (i) a first
3 preform having a thickness of about 3mm at the center
4 side wall forming portion, a thickness of about 3mm in
5 the base forming portion, and a length of about 40mm, to
6 (ii) a second preform having a thickness of about 8.0mm
7 at the center side wall forming portion, a thickness of
8 about 8.0mm in the base forming portion, and a length of
9 about 100mm.

1 9. The injection molded preform according to claim
2 1, wherein said preform is not of a laminated
3 construction.

1 10. The injection molded preform according to
2 claim 1, wherein said preform is injection molded from
3 a physical mixture of (i) 5 to 76wt% of a first
4 component of a PEN copolymer based on the total weight
5 of the preform, and (ii) 24 to 95wt% of a second
6 component of PET homopolymer or PET copolymer based on
7 the total weight of the preform.

1 11. The injection molded preform according to
2 claim 1, wherein said preform is injection molded from
3 a physical mixture of (i) 5-76% wt% of a first component
4 of a PEN copolymer based on the weight of the preform,
5 said PEN copolymer comprising about 5 to 8 mol%
6 terephthalate or other diacid and (ii) 24-95wt% of a
7 second component of PET homopolymer or PET copolymer,
8 said blend being injection molded such that the preform
9 has a thickness in the range of 3 to 5.7mm at the center
10 side wall forming portion and a thickness in the range
11 of 3 to 5.3mm in the base forming portion, the length of
12 the preform being in the range of 73 to 80mm.

1 12. The injection molded preform according to
2 claim 10, wherein the second component includes up to
3 25wt% PET copolymer.

1 13. The injection molded preform according to
2 claim 6, wherein said preform is comprised of a PEN
3 copolymer which is a reaction product of about 0.5 to
4 99.9 mol% NDC, about 0.1 to 99.5 mol% of another diacid,
5 and a total equimolar portion of a dihydroxy compound.

1 14. The injection molded preform according to
2 claim 6, wherein said preform is comprised of a PEN
3 copolymer which is a reaction product of about 5 to 50
4 mol% NDC, about 50 to 95 mol% of another diacid and a
5 total equimolar portion of dihydroxy compound.

1 15. The injection molded preform according to
2 claim 6, wherein said preform is comprised of a PEN
3 copolymer which is a reaction product of about 15 to 50
4 mol% NDC, about 65 to 95 mol% terephthalic acid, and a
5 total equimolar portion of dihydroxy compound.

1 16. The injection molded preform according to
2 claim 6, wherein said preform is comprised of a PEN
3 copolymer which is a reaction product of about 5 to 20
4 mol% NDC, about 80 to 95 mol% terephthalic acid and a
5 total equimolar portion of ethylene glycol.

1 17. The injection molded preform according to
2 claim 1, wherein said preform is injection molded from
3 a 5 mol% to 25 mol% PEN copolymer based on the total
4 weight of the preform.

1 18. The injection molded preform according to
2 claim 1, wherein said preform is injection molded from
3 a 0.5 mol to 50 mol% NDC containing PEN copolymer.

1 19. An injection mold defining a cavity
2 corresponding to an injection molded preform of Figure
3 1.

1 20. An injection mold defining a cavity
2 corresponding to an injection molded preform of Figure
3 2.

1 21. An injection mold defining a cavity
2 corresponding to an injection molded preform of Fig. 13.

1 22. A blow-molded container produced from the
2 injection molded preform of claim 1.

1 23. A blow-molded container produced from the
2 injection molded preform of claim 1, wherein said
3 container is a bottle having a volume of about 250, 300,
4 333, 355, 472, 500, 590, 750 or 850 ml.

1 24. A blow-molded container produced from the
2 injection molded preform of claim 3, wherein said
3 container is a bottle having a volume of about 250 ml,
4 300 ml, 333ml, 355 ml, 472ml, 500 ml, 590 ml, 750ml,
5 850ml or 1000 ml.

1 25. A blow-molded container produced from the
2 injection molded preform of claim 1, wherein said
3 container is a bottle having a volume of about 12
4 ounces, 16 ounces, 20 ounces or 24 ounces.

1 26. An injection molded preform comprising an open
2 ended mouth forming portion, an intermediate body
3 forming portion, and a closed base forming portion, said
4 preform comprising PEN and having a stretch ratio in the
5 range of 18:1 to 25:1 in order form a bottle having a
6 volume in the range of 250 ml to 850 ml, and wherein
7 said preform ranges in size from (i) a first preform
8 having a thickness of about 3mm at the center side wall
9 forming portion, a thickness of about 3mm in the base
10 forming portion, and a length of about 40mm, to (ii) a
11 second preform having a thickness of about 8.0mm at the
12 center side wall forming portion, a thickness of about
13 8.0mm in the base forming portion, and a length of about
14 100mm, wherein the stretch index is below 130 cm.

1 27. An injection molded preform comprising an open
2 ended mouth forming portion, an intermediate body
3 forming portion, and a closed base forming portion, said
4 preform having a stretch ratio in the range of 18:1 to
5 21:1 in order form a bottle having a volume in the range
6 of 250 ml to 1000 ml, and wherein said preform ranges in
7 size from (i) a first preform having a thickness of
8 about 3mm at the center side wall forming portion, a
9 thickness of about 3mm in the base forming portion, and
10 a length of about 40mm, to (ii) a second preform having
11 a thickness of about 8.0mm at the center side wall

12 forming portion, a thickness of about 8.0mm in the base
13 forming portion, and a length of about 110mm, wherein
14 the stretch index is below 130cm.

1 28. A method for producing a container which
2 comprises:

3 forming a preform of (1) a physical blend of (i)
4 PEN copolymer and (ii) PET homopolymer or PET copolymer,
5 such that when said PET and PEN components are
6 physically mixed into a blend, said blend contains about
7 5-99.9wt% PEN copolymer and about 0.1 to 95wt% PET
8 homopolymer or copolymer therein, (2) a 0.5 to 99.9 mol%
9 NDC containing PEN copolymer, or (3) PEN homopolymer,
10 and

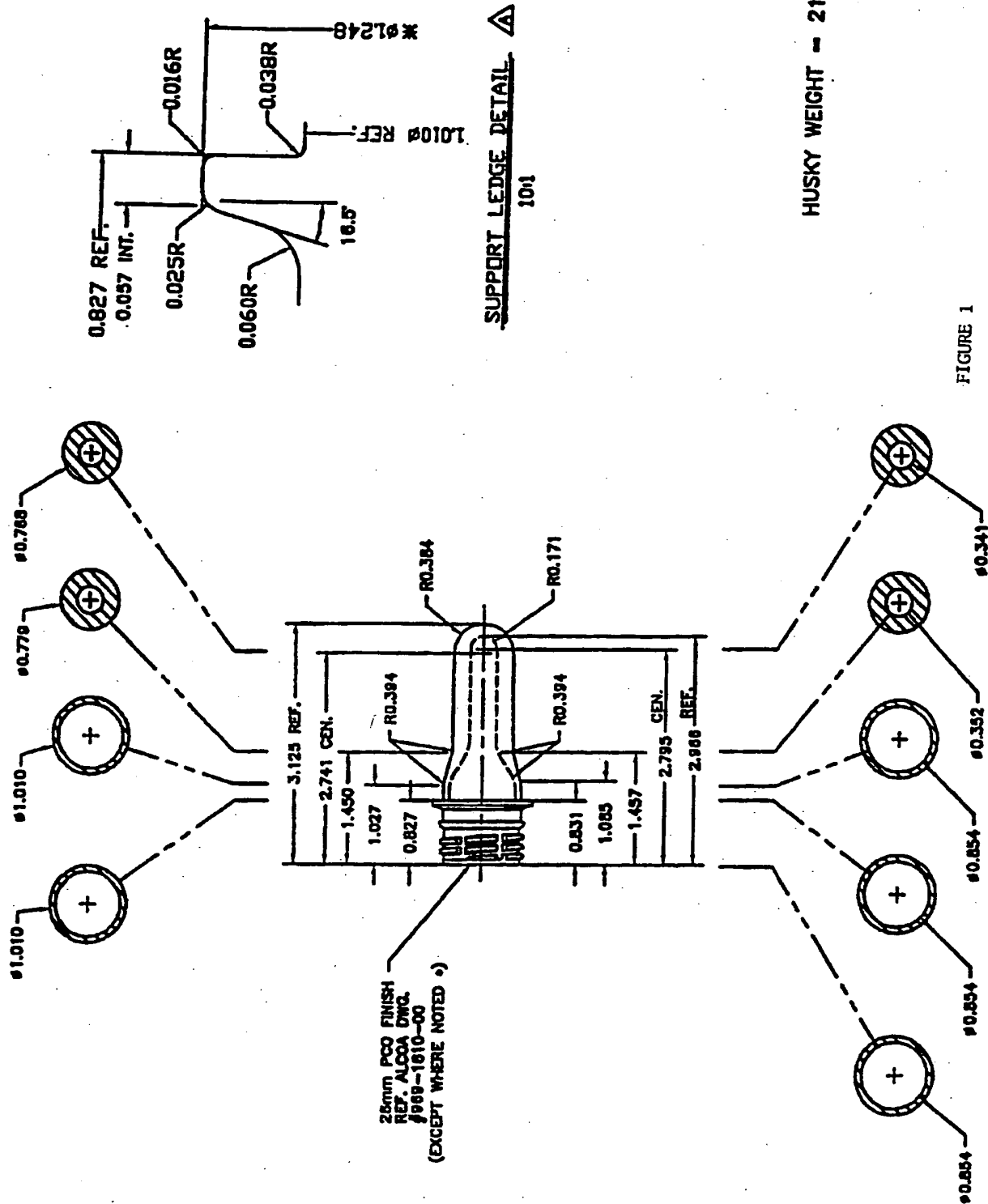
11 blow molding the preform so that the stretch ratio
12 is in the range of 18:1 to 25:1 in order form a bottle
13 having a volume in the range of 250 ml to 850 ml,
14 wherein the stretch index is below 130cm.

1 29. A method for producing a container which
2 comprises:

3 forming a preform of (1) a physical blend of (i)
4 PEN copolymer and (ii) PET homopolymer or PET copolymer,
5 such that when said PET and PEN components are
6 physically mixed into a blend, said blend contains about
7 5-99.9wt% PEN copolymer and about 0.1 to 95wt% PET
8 homopolymer or copolymer therein, (2) a 0.5 to 99.9 mol%
9 NDC containing PEN copolymer, or (3) PEN homopolymer,
10 and

11 blow molding the preform so that the stretch ratio
12 is in the range of 18:1 to 20:1 in order to form a
13 bottle having a volume in the range of 250 ml to 1000
14 ml, wherein the stretch index is below 130 cm.

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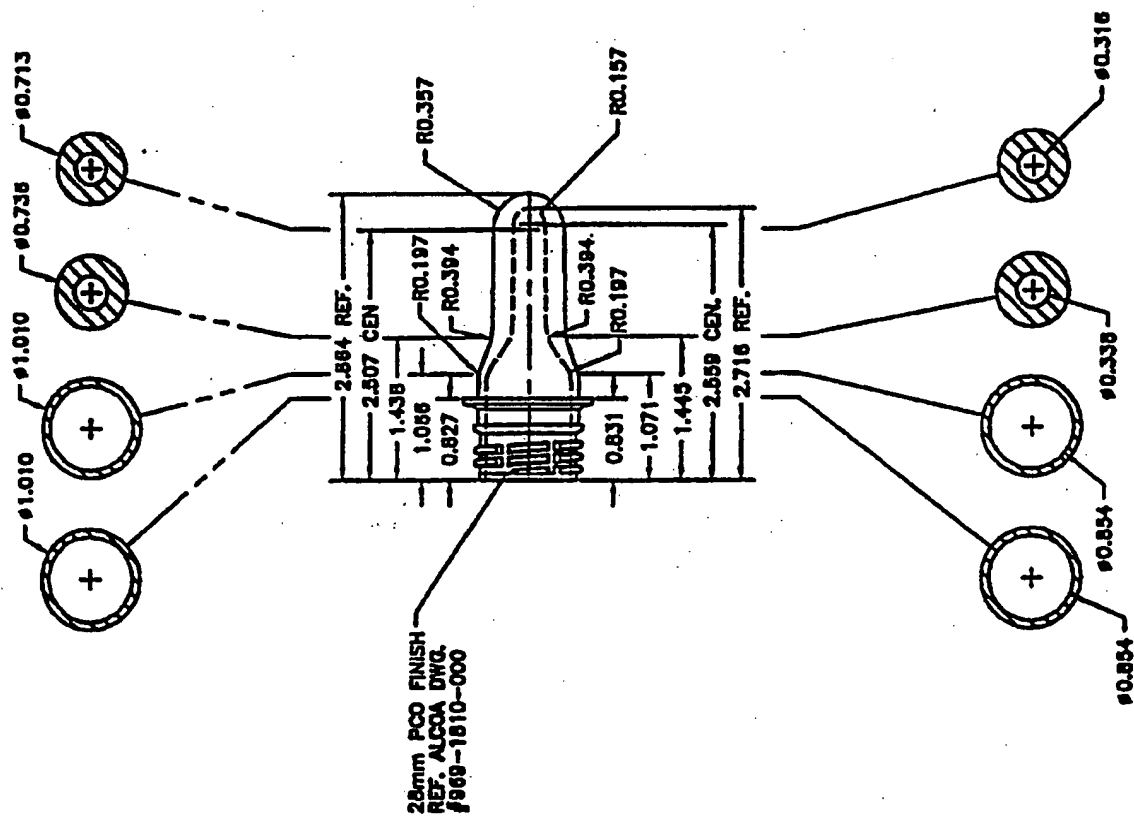


FIGURE 2

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FIG. 3

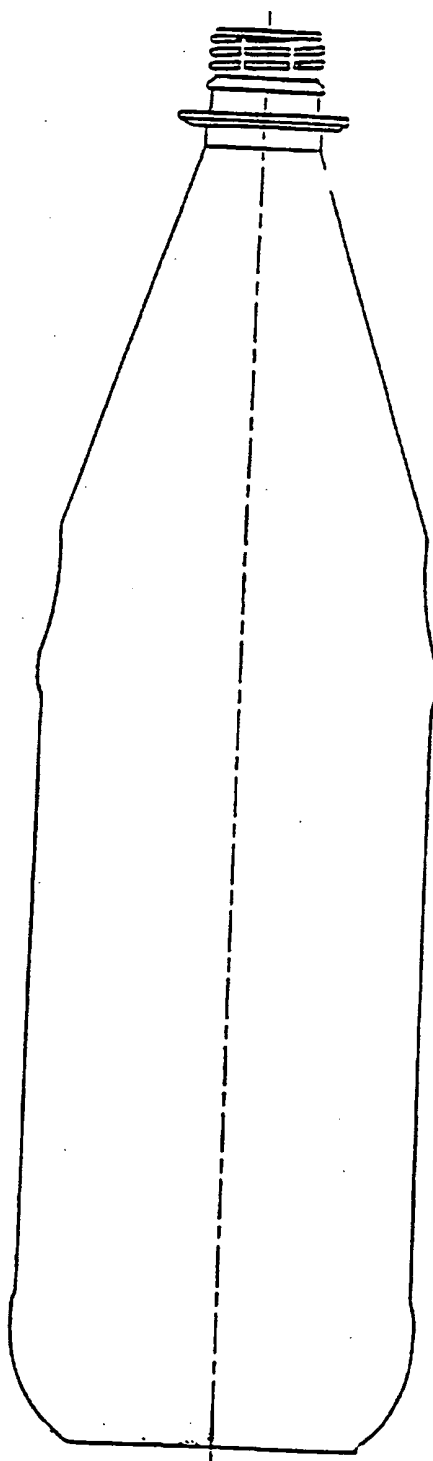


FIG. 4

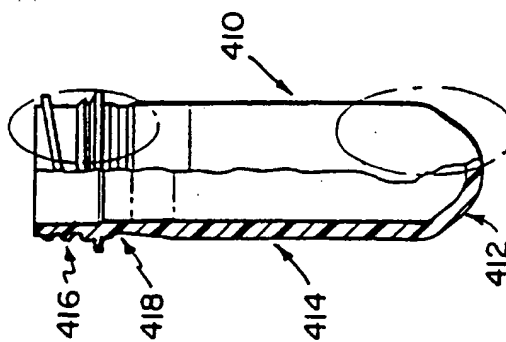


FIG. 5

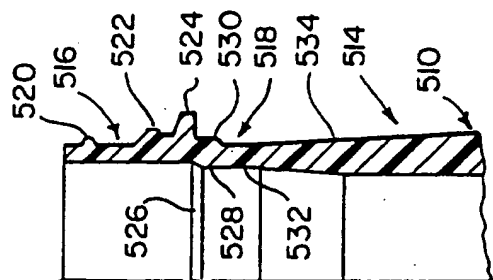
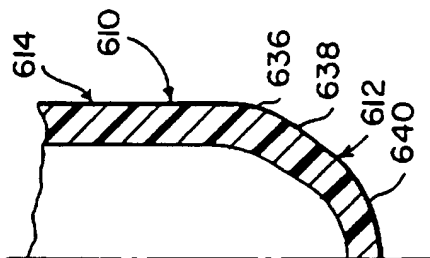


FIG. 6



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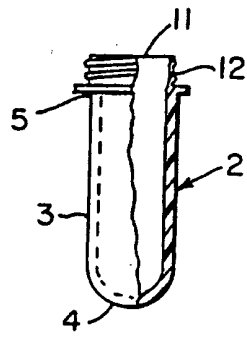


FIG. 7

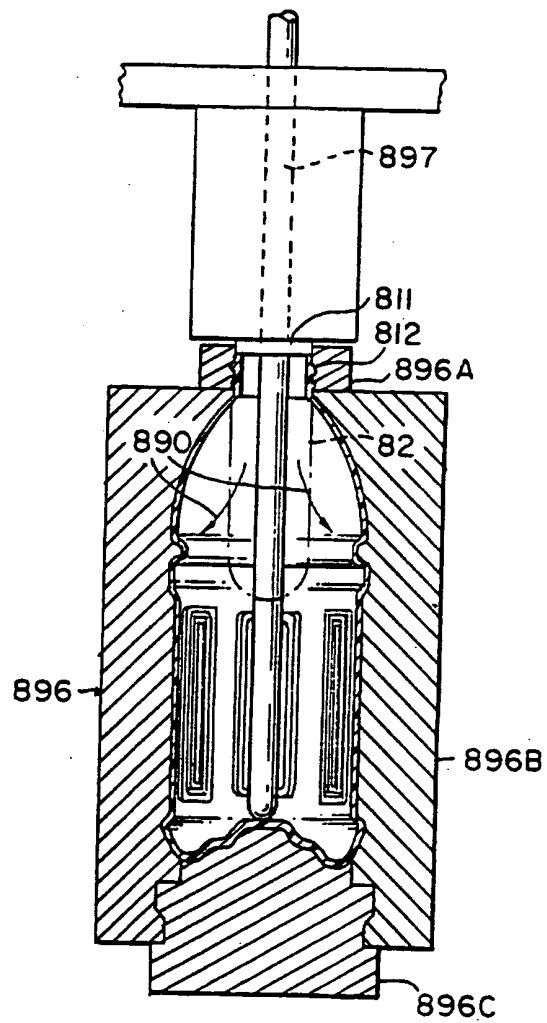


FIG. 8

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FIG. 10

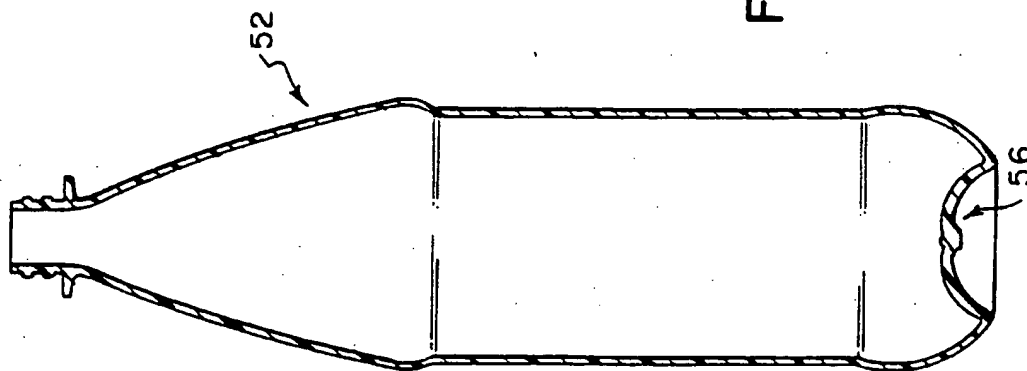
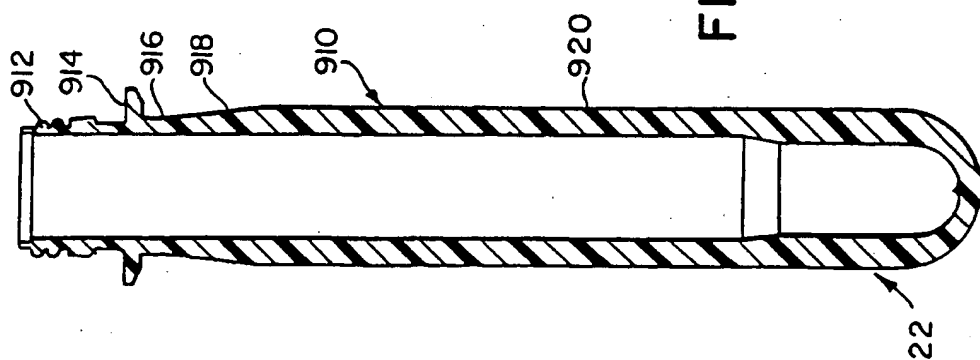


FIG. 9



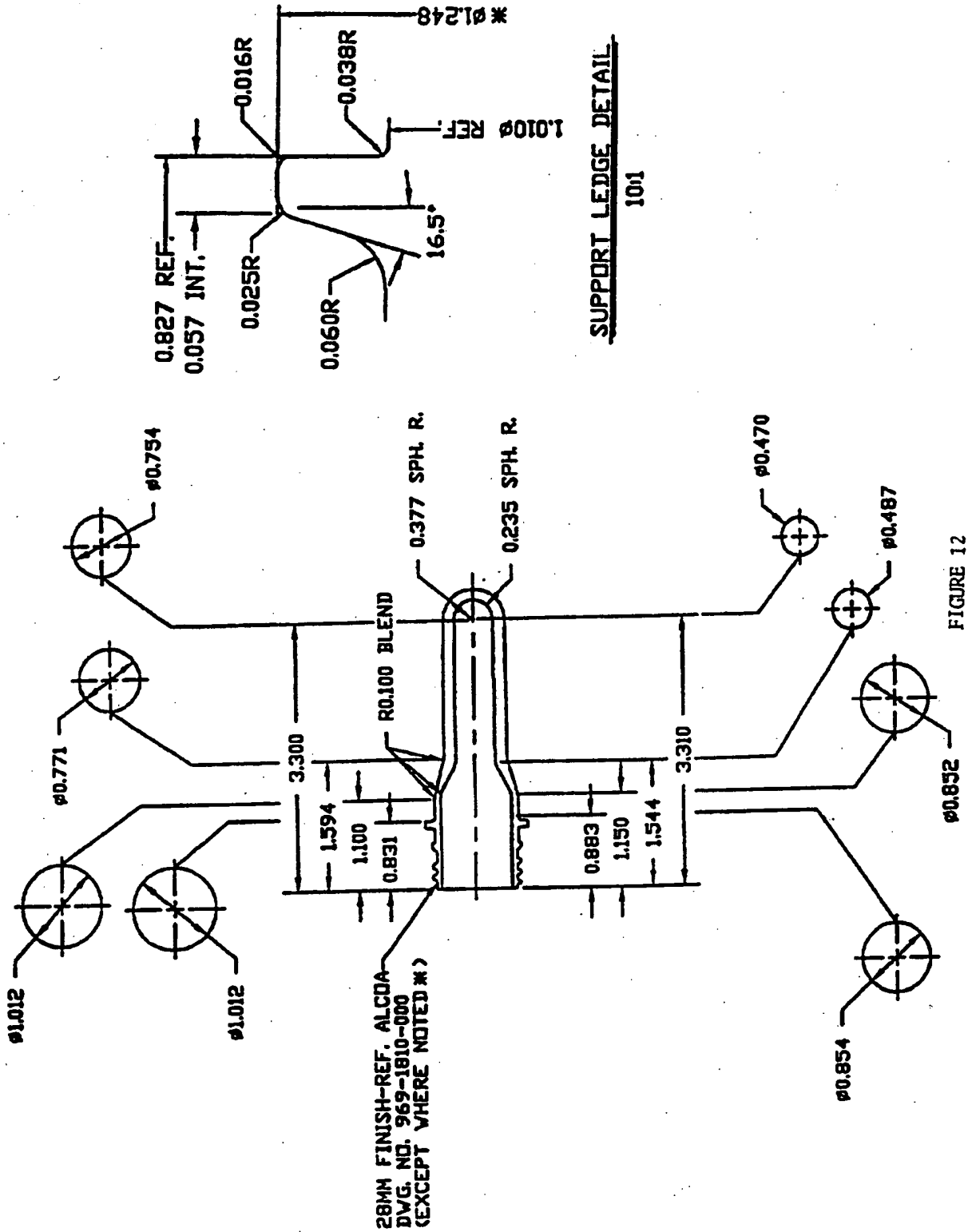
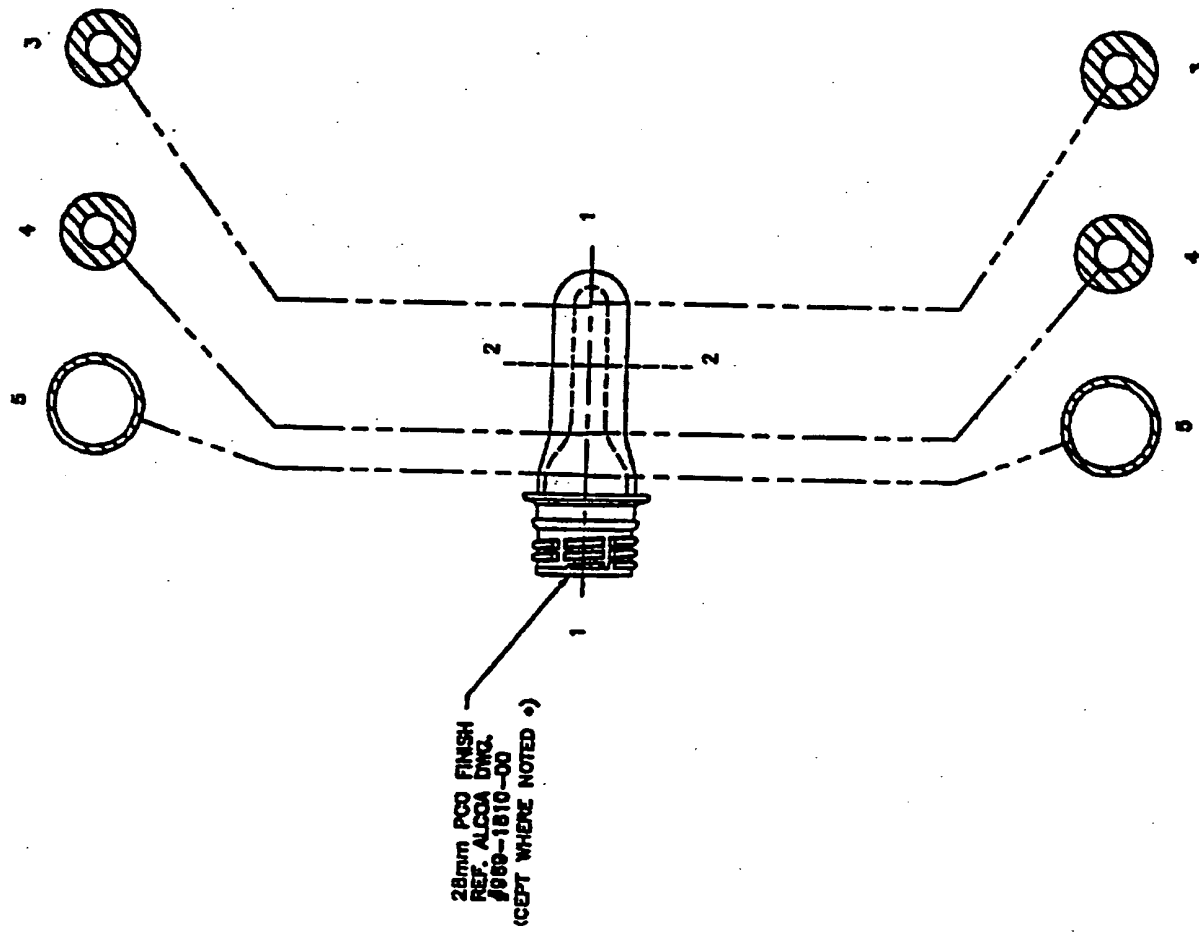
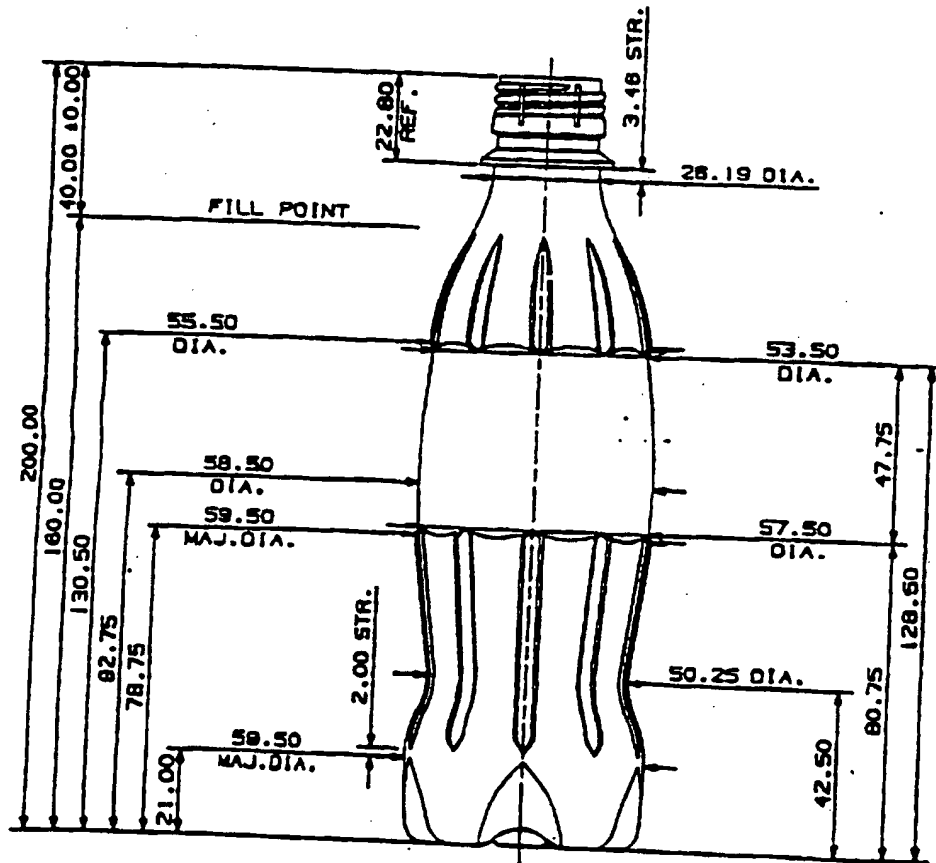


FIGURE 12



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FIG. 14



INTERNATIONAL SEARCH REPORT

Inte. nal Application No
PCT/US 96/05507

A. CLASSIFICATION OF SUBJECT MATTER
IPC 6 B29C49/00

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 6 B29C B65D

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	RESEARCH DISCLOSURE, no. 294, 1 October 1988, pages 714-719, XP000068665 "POLY(ETHYLENE NAPHTHALENEDICARBOXYLATE)/POLY(ETHYLENE TEREPHTHALATE) BLENDS"	1-5, 9-12, 22-25
A	see page 714, left-hand column, line 22 - line 25; example 2	28,29
X	RESEARCH DISCLOSURE, no. 283, November 1987, pages 739-741, XP000027630 "POLYESTERS WITH GOOD EXTRUSION BLOW-MOLDING CHARACTERISTICS" see example 1	1,7

☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

* Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

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"&" document member of the same patent family

Date of the actual completion of the international search

9 July 1996

Date of mailing of the international search report

24.07.96

Name and mailing address of the ISA

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Fax (+ 31-70) 340-3016

Authorized officer

Attalla, G

INTERNATIONAL SEARCH REPORT

Int. Patent Application No.
PCT/US 96/05507

C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	<p>DATABASE WPI Section Ch, Week 9127 Derwent Publications Ltd., London, GB; Class A23, AN 91-197224 XP002007974 & JP,A,03 122 116 (MITSUI PETROCHEM IND KK) , 24 May 1991 see abstract</p> <p style="text-align: center;">---</p>	1,6,13, 14,16-18
A	<p>EP,A,0 247 566 (CONTINENTAL PET TECHNOLOGIES) 2 December 1987 see page 3, line 12 - line 16; figure 2</p> <p style="text-align: center;">---</p>	26-29
A	<p>DATABASE WPI Section Ch, Week 8919 Derwent Publications Ltd., London, GB; Class A92, AN 89-141174 XP002007975 & JP,A,01 085 732 (UNITIKA KK) , 30 March 1989 see abstract</p> <p style="text-align: center;">---</p>	13
A	<p>EP,A,0 383 324 (MITSUI PETROCHEMICAL IND) 22 August 1990 cited in the application see the whole document</p> <p style="text-align: center;">---</p>	1
A	<p>EP,A,0 415 728 (MITSUI PETROCHEMICAL IND) 6 March 1991 see claims</p> <p style="text-align: center;">-----</p>	1

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US 96/05507

Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This international search report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:
2. ☒ Claims Nos.: 19-21
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:
see PCT Rule 6.2(a)
3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

1. ☐ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:
4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
- ☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT

International Application No
PCT/US 96/05507

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